



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D3220-042
Job Sheet 177040



Part No: D3220-042

Job Qty: 4 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 5/24/18

Description:

Type: Stock

Note: DWG REV B IPP Rev:A New Issue 05-11-06 JLM IPP: B 06.11.15 waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Waterjet		DL 18/05/10
100	Waterjet	4 pcs	5/24/18	5/24/18	0.06	0.32	Waterjet1		DL 18/05/10
110	QC	4 pcs	5/24/18	5/24/18	0.00	0.00	QC2 Waterjet-1		DL 18/05/10
120	QC	4 pcs	5/24/18	5/24/18	0.00	0.00	QC8-2		38
130	Small Fab	4 pcs	5/24/18	5/24/18	0.00	0.29	Small Fab-3		9-89 DAS 38
140	QC	4 pcs	5/24/18	5/24/18	0.00	0.00	QC5		38
150	HandFinish	4 pcs	5/24/18	5/24/18	0.00	0.39	HandFinish1		SA 18-08-22
160	QC	4 pcs	5/24/18	5/24/18	0.00	0.00	QC3		38
170	Small Fab	4 pcs	5/24/18	5/24/18	0.00	0.29	Small Fab-3		DAS 38
180	QC	4 pcs	5/24/18	5/24/18	0.00	0.00	QC5	DAS 6	38
190	Packaging	4 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1	6	MAY 25 2018
200	QC21-SA	4 Ea	5/24/18	5/24/18	0.00	0.00	QC21	89	

Part Op 100 - 1-Cut D3220-2 as per Dwg D3220
Descriptions: 130 - 1-Deburr 2-C'sink D3220-2 as per Dwg D3220
170 - Assemble D3220-042 doubler as per Dwg D3220

DAS
21 MAY 25 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.7704 sf (.6926 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	32 Ea (8 ea)	170-Small Fab	5048535
MS21059L4	Nutplate	16 Ea (4 ea)	170-Small Fab	5043786

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	3	92	0
170-Small Fab	MS20426AD3-3	32	4,948	0
	MS21059L4	16	58	0

Part Specifications

Specifications could not be found.

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CART
AEROSPACE



Container No: S070349

Part: D3220-042
Job No: 177040
Serial No/Batch: S070349
Revision:
Inspector:

Date: 06/10/18

DART AEROSPACE LTD		Work Order: 177040
Description: Doubler		Part Number: D3220-2
Inspection Dwg: D3220	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50	+/-0.030	5.50	1		V: 0.03	
14.25	+/-0.030	14.25	1		Top	
R0.50	+/-0.030	.50	1			
7.00	+/-0.030	7.00	1			
7.000	+/-0.005	6.999	1			
1.50	+/-0.030	1.50	1			
1.000	+/-0.005	1.001	1			
0.500	+/-0.005	.499	1			
1.000	+/-0.005	.998	1			
Ø0.316	+0.006/-0.001	Ø.315	1			
Ø0.098	+0.004/-0.001	Ø.100	1			
0.050 thick	+/-0.005	.050	1			
Grain Direction	N/A	1	1			

Measured by: <i>de</i>	Audited by: <i>DAS 38</i>	Preliminary Approval:
Date: 18/05/10	Date: MAY 11 2018	Date:

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue P/O D3220-042	KJ/JLM	
B	13.03.07	Dwg Rev updated	KJ	